



Dart Aerospace Ltd.
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D5669-041

Job Sheet 199419



Part No: D5669-041

Job Qty: 1 pcs

Part Name: Long Basket Lid Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/22/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/12/19

Description:

Type: SOLD

Note: TBD DWG D5669 REV.A IPP REV:A 18.07.23 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	9/12/19	9/12/19	0.00	30.30	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	9/12/19	9/12/19	0.00	0.00	QC 9 - 10		SEP 1 2 2019
							QC 9 - 18		
							QC 9 - 24	DAS 24	
							QC 9 - 43	9-89	
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	9/12/19	9/12/19	0.00	0.00	QC 5 - 10		SEP 1 2 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24	DAS 24	
							QC 5 - 3	9-89	
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		



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Container No: S213229



Part: D5669-041

Job No: 199419

Serial No/Batch: S213229

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 09/12/19

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						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
130 Powdercoat - 2 White Gl(S)- B4B	1 pcs	9/12/19	0.00	0.40	Powdercoat - 1 - B4B		
<i>M 193454</i> <i>START: 8.55 ON 1375° FINISH 10.25</i>					Powdercoat - 2 - B4B		
					Powdercoat - 3 - B4B		
					Powdercoat - 4 - B4B		
135 QC 3	1 pcs	9/12/19	0.00	0.00	QC 3 - 10		
					QC 3 - 13		
					QC 3 - 15		
					QC 3 - 17		
					QC 3 - 18		
					QC 3 - 2		
					QC 3 - 28		
					QC 3 - 3		
					QC 3 - 30		
					QC 3 - 34		
					QC 3 - 36		
					QC 3 - 41		
					QC 3 - 51		
					QC 3 - 58		
					QC 3 - 59		
					QC 3 - 68		
					QC 3 - 9		
					QC 3 - 40		
					QC 3 - 19		
					QC 3 - 43		
					QC 3 - 24		
					QC 3 - 61		
					QC 3 - 81		
140 Handfinish - 4-1-Assembly- B4B	1 pcs	9/12/19	0.00	0.80	Handfinish - 4 - 1 - B4B		
					Handfinish - 4 - 10 - B4B		
					Handfinish - 4 - 11 - B4B		
					Handfinish - 4 - 12 - B4B		
					Handfinish - 4 - 13 - B4B		
					Handfinish - 4 - 14 - B4B		
					Handfinish - 4 - 15 - B4B		
					Handfinish - 4 - 2 - B4B		
					Handfinish - 4 - 3 - B4B		
					Handfinish - 4 - 4 - B4B		
					Handfinish - 4 - 5 - B4B		
					Handfinish - 4 - 6 - B4B		
					Handfinish - 4 - 7 - B4B		
					Handfinish - 4 - 8 - B4B		
					Handfinish - 4 - 9 -		

DAS
15
9-89

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				B4B	
150 QC 5	1 pcs	9/12/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
160 Packaging 3-1 - Stock - B4B	1 pcs	9/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	1 pcs	9/12/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

DAS
SEP 17 2019 40
9-89

pl 12-9-17

DAS
21
9-89 SEP 17 2019

Part Op 100 - 1- Assemble ribs , weld as per dwg D5669 using DT9607A 2- Weld hinge (3) and Mounting brackets as per dwg
 Descriptions: D3914 ***Visual inspect before welding mesh*** 4- Cut lid mesh as per dwg 4- Tack weld mesh on basket as per dwg
 D5669 ***Cut out mesh where label plate goes in center off basket lid as per dwg. Make sure to place mesh correctly on
 lid, check with label plate before tacking mesh*** ***CUT OUT MESH ON TOP OF D2581 1.5" HIGH*** ***DOUBLE
 CHECK WITH A HANDLE*** 5- ****SCRIBE ID AS PER DWG NOTE 6 ON SHEET 1****
 110 - (QC9- Inspect visual per QSI004- Fusion Welds)
 120 - (QC5- Inspect part completeness to step on W/O) ****SCRIBE ID AS PER DWG NOTE 6 ON SHEET 1****
 130 - *** Mask holes as per note 9, sides of hinge and note 11 prior to powdercoat*** START TIME: _____ OVEN
 TEMPERATURE: _____ FINISH TIME: _____
 135 - (QC3- Inspect Part Finish)
 140 - (Assemble as per dwg) 1- Assemble as per dwg 2- Mask data plate and apply wing walk on outside surface of mesh
 as per dwg and QSI Wing Walk batch: 5208632
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Identify as per dwg & Stock Location: _____)
 170 - QC21 (QC21- Final Inspection - Work Order Release)

011874

Job BOM

Part / Item	Component Name	Quantity	Operation
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1
D3914-1	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1
D4016-3	Hinge Half, Lid	3 pcs (3 ea)	100-Large Fab - Basket - 1
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	100-Large Fab - Basket - 1
D5670-1	Rib	4 pcs (4 ea)	100-Large Fab - Basket - 1
D5670-3	Rib	9 pcs (9 ea)	100-Large Fab - Basket - 1
D5672-1	Data Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1
AN3-14A	Bolt	4 Ea (4 ea)	140-Handfinish - 4-1-Assembly-B4B
AN3-16A	Bolt	2 Ea (2 ea)	140-Handfinish - 4-1-Assembly-B4B
AN5-17A	Bolt	2 Ea (2 ea)	140-Handfinish - 4-1-Assembly-B4B
D2530	Handle Weldment	1 pcs (1 ea)	140-Handfinish - 4-1-Assembly-B4B
D2535	Spring	2 pcs (2 ea)	140-Handfinish - 4-1-Assembly-B4B
D2537	Bushing	2 pcs (2 ea)	140-Handfinish - 4-1-Assembly-B4B
D3953-17	Gas Spring Spacer	2 pcs (2 ea)	140-Handfinish - 4-1-Assembly-B4B
D3953-19	Gas Spring Bracket	2 pcs (2 ea)	140-Handfinish - 4-1-Assembly-B4B
MS21042L3	Nut	6 Ea (6 ea)	140-Handfinish - 4-1-Assembly-B4B
MS21042L5	Nut	2 Ea (2 ea)	140-Handfinish - 4-1-Assembly-B4B
NAS1149F0332P	Washer (AN960-10L)	8 Ea (8 ea)	140-Handfinish - 4-1-Assembly-B4B
NAS1149F0563P	Washer (AN960-516)	2 Ea (2 ea)	140-Handfinish - 4-1-Assembly-B4B

011947
 Container
 S200407
 S207850
 S193147
 S193477
 S197319
 S197639
 S133197
 S206863
 S21368941
 S205082
 S213660
 S203282
 S154034
 S123161
 S201821
 S184417
 S2012832
 S208679
 S155976
 S203116

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	46	0
	D3914-1	2	10	0
	D4016-3	3	68	0
	D4035-043	2	8	0
	D5670-1	4	4	0
	D5670-3	9	13	0
	D5672-1	1	2	0
	M304EX0.75-16F	32	1,163	0
	AN3-14A	4	202	0
	AN3-16A	2	143	0
140-Handfinish - 4-1-Assembly-B4B	AN5-17A	2	70	0
	D2530	1	9	0
	D2535	2	166	0
	D2537	2	104	0
	D3953-17	2	47	0
	D3953-19	2	52	0
	MS21042L3	6	1,755	0
	MS21042L5	2	235	0
	NAS1149F0332P	8	2,910	0
	NAS1149F0563P	2	281	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION			DEPARTMENT/PROCESS						
Date: _____		Sequence #: _____			QTY Affected: _____						
Description Work Order Deviation		Disposition									
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled Other/Details: _____		☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up		☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Completed By _____		Lead hand / Supervisor _____		QC / QA Coordinator _____							
MRB (QS1042)											